

Work Order ID 71063

Tuesday, June 21, 2011 1:33:43 PM

Page 1

Item ID: D2933-2

Accept

Revision ID:

Item Name: Saddle RH In, 206

Start Date: 6/21/2011 Start Qty: 4.00

Required Date: 7/8/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2933	Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

SL 11/07/04

4

0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11/07/04

4

0

120

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

SL 11/07/04

4

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 71063




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Page 2

Item ID: D2933-2 Accept  Setup Start 
Revision ID: Stop 
Item Name: Saddle RH In, 206
Start Date: 6/21/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 7/8/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 11/07/04		4	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	0	11/07/05	
155  SprayPaint Spray Painting	 Memo PRIME B 117319 DELFLEET BLUE B 115985 DELFLEET CLEAR B 117113	0.00 0.00				m	11	07	13 (4)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 71063

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Page 3

Item ID: D2933-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH In, 206

Start Date: 6/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

BT 11-07-14 (x4)

170

Identify as per dwg & Stock Location: 424

0.00



Packaging

Memo

0.00

Packaging

11/7/15 SL (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/15 ME 11-07-15

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 71063



Parent Item: D2933-2



Parent Item Name: Saddle RH In, 206

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001

Manufactured

No

100

Each

49.0000

1

4



Saddle Billet

2 11/07/04

Location

Loc Qty

Loc Code

MAT040

44

64777

20

66965

4

69677

20

MAT40

5

69700

5

4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71063
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123	.121	.121	.121		
B	0.100	0.140		.123	.121	.121	.121		
C	0.100	0.140		.122	.120	.120	.119		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.237	.238			
N	0.100	0.140		.119	.118	.118	.119		
O	0.540	0.560		.548	.549	.550	.549		
P	0.490	0.510		.496	.500	.498	.495		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.250	.249	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.136	1.135	1.134	1.135		
Y	1.565	1.585	DT8695 A/B	1.576	1.575	1.574	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	11/07/04

Audited by:	B.A
Date:	11/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

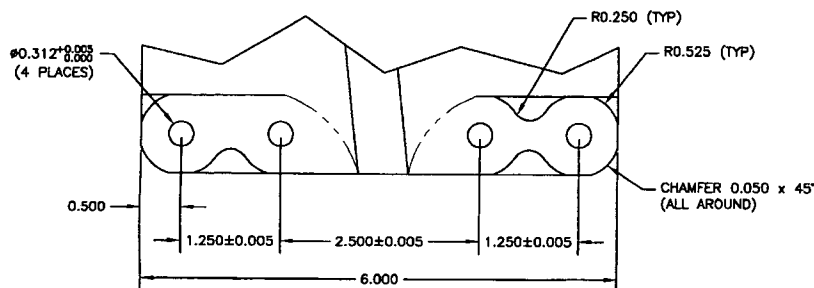
W/O:		WORK ORDER CHANGES					
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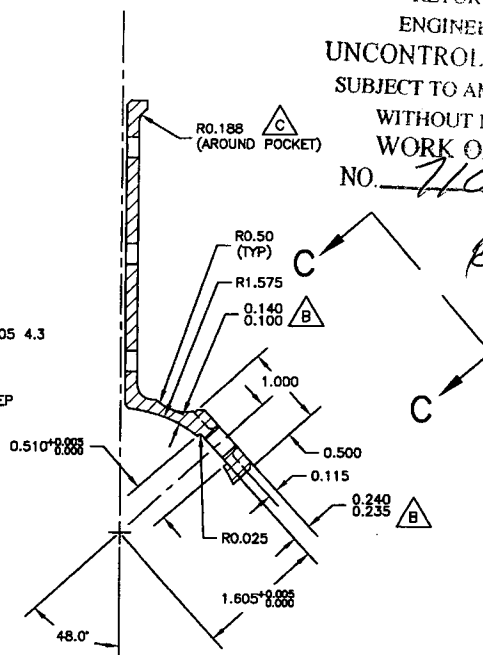


VIEW C-C

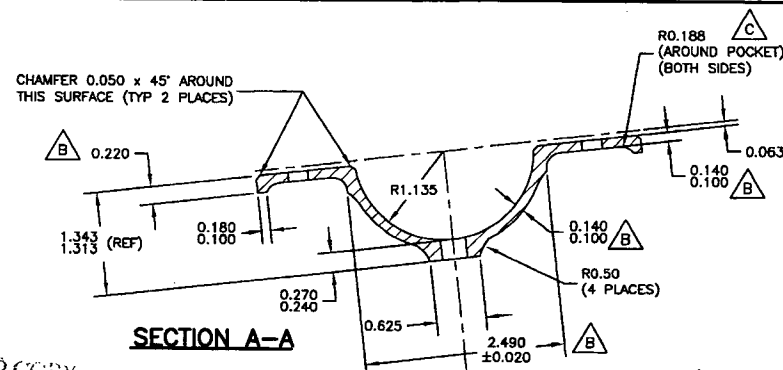
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

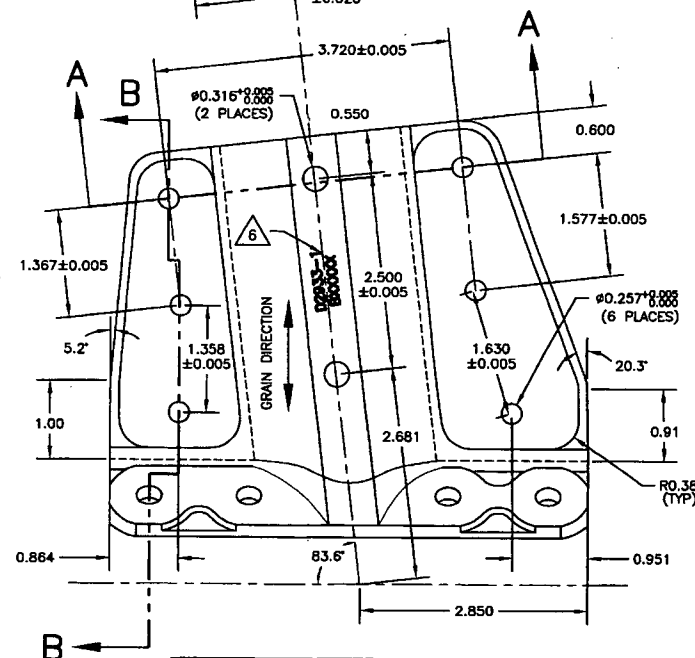
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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DART DART AEROSPACE USA, INC. BELLEVUE, WA

DRAWING NO. D2933

REV. C SHEET 1 OF 1

SCALE 2:3

RELEASED

07-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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